

Work Order ID 70613

Monday, June 13, 2011 12:33:40 PM



Page 1

Item ID: D3307-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 6-16-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3307	Rev A								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

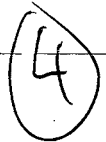
FLOW CNC Waterjet

1-Cut D3307-1 as per Dwg D3307 ☐ Dwg Rev: A ☐ Prog

304 .032

Rev: A ☐ 2-Deburr if necessary

B11-7-5



110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-7-5

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/16/07/06



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

bend as per dwg D3307

EP 11/07/06 (4)

140



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Bond gasket as per dwg D3307

EP 11/07/06 (4)

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

8/11/06

(4)

W/O:		WORK ORDER CHANGES					
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Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location 232A

0.00



Packaging

Memo

0.00

Packaging

11/7/11 (4) S

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/11

MF 11-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 12:33:46 PM

Page 1

Work Order ID: 70613

Parent Item: D3307-041

Parent Item Name: Access Panel Assembly



Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 08.08.05 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3307-3 Gasket		Manufactured	No			100	Each	5.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST232A				5					
				44725				5					
M304S22GA 304/316 .032 Sheet		Purchased	No			140	sf	56.5600	0.26	1.04			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				020				7					
				109057				7					
				MAT020				49.56					
				117379				49.56					

4511/07/06

4

B11-7-5

(4)

117379

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Dart Aerospace Ltd

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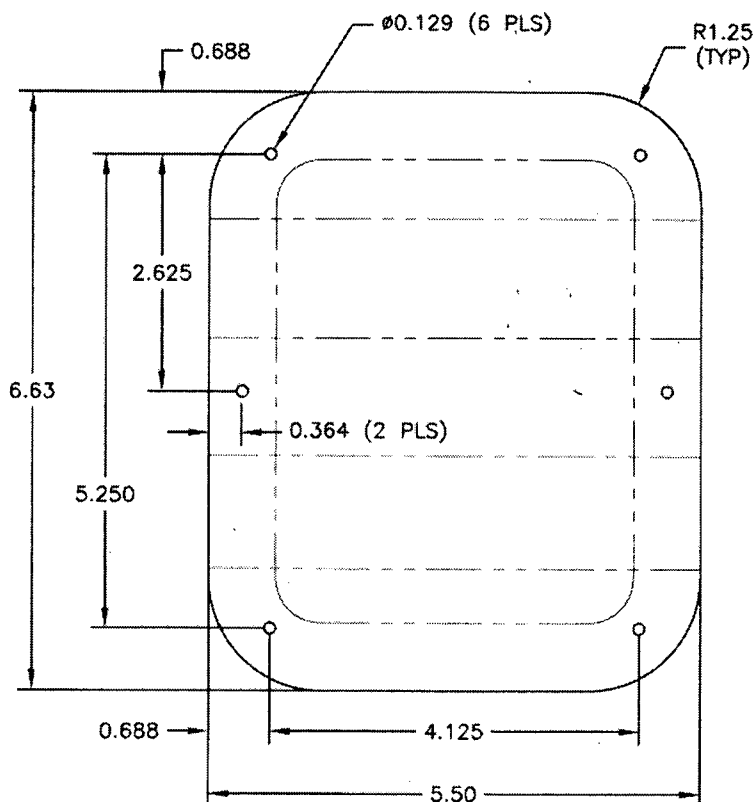
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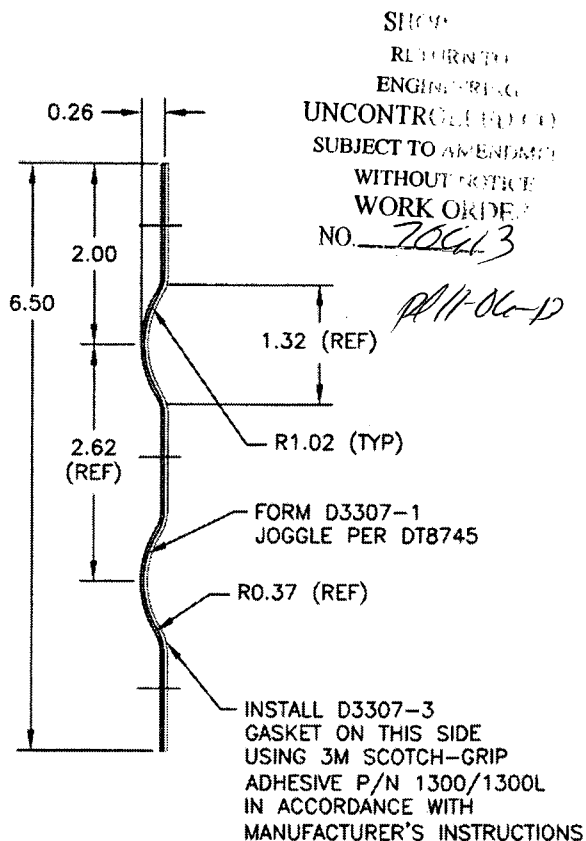


DESIGN 4-7	DRAWN BY F	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3307	REV. A SHEET 1 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2
A	04.09.23	NEW ISSUE	

RELEASED
05.01.18



D3307-1 PANEL FLAT PATTERN



D3307-041 BEND DETAIL
IDENTIFY WITH P/N & B/N
USING FINE POINT
PERMANENT MARKER

D3307-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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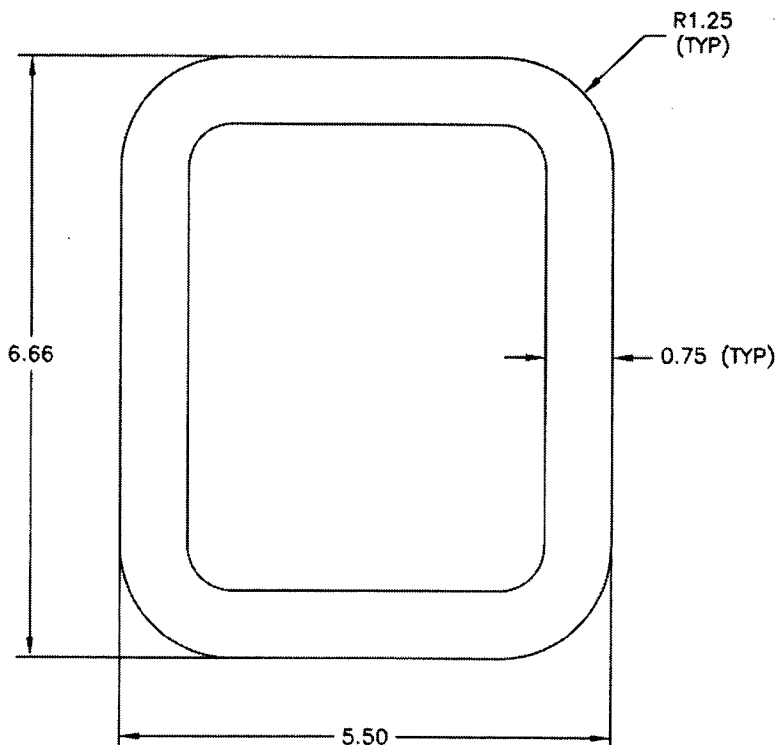
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3307	REV. A SHEET 2 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2

RELEASED
65-01.18 *[Signature]*

u/o 7dec13



D3307-3 GASKET

D3307-3 NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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